

stud ZX In order to locate the spider centrally in the jig, that is, so that the arms will come in average alignment with the four bushings, the centering device *E* is employed, By means of a spring *P*, the end of which is attached to the bent end of the part *E*, the two aligning lingers are brought to bear simul-



fig. 13.

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taneously against opposite arms of the spider, thus locating the spider in a central position in the jig. After this it is a simple matter to drill and countersink the spider arms one after another, indexing the jig by hand for each arm.

An idea of the facility with which this jig is operated can be gathered from the fact that 500 of these spiders are drilled